

Date: Wednesday, 3/7/2007 3:51:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB (LAMA)
Job Number : 31065	
Estimate Number : 11589	
P.O. Number : N/A	Part Number : D2905
This Issue : 3/7/2007 S.O. No. : N/A	Drawing Number : D2905 REV A 1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A1
Previous Run : N/A	Material : N/A
Type : LANDING GEAR	Due Date : 4/30/2007
Qty: 8	Um: Each
Written By : <u>HA</u>	
Checked & Approved By : <u>HA 07.03.19</u>	
Comment : Est. A 00.01.11 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D26005108	Extrusion 'I Beam' thin
-----	-----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

D2600-5-108 Extrusion 'I Beam' thin

Batch: B 29985

507-4-11

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 Extrusion to length as per Dwg D2905

2-Debur ends

3- Drill pilot holes in web as per Dwg D2905 using drill jig DT8430

4- Open holes to finish size as per Dwg D2905

5- Debur

507-4-11

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

AE 07-04-11

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

507-4-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 27/04/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 3:51:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB (LAMA)

Job Number: 31065

Part Number: D2905

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



fm'07-04-12(8)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

fm'07-04-12(8)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

2007/04/13

Job Completion



U 5F.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

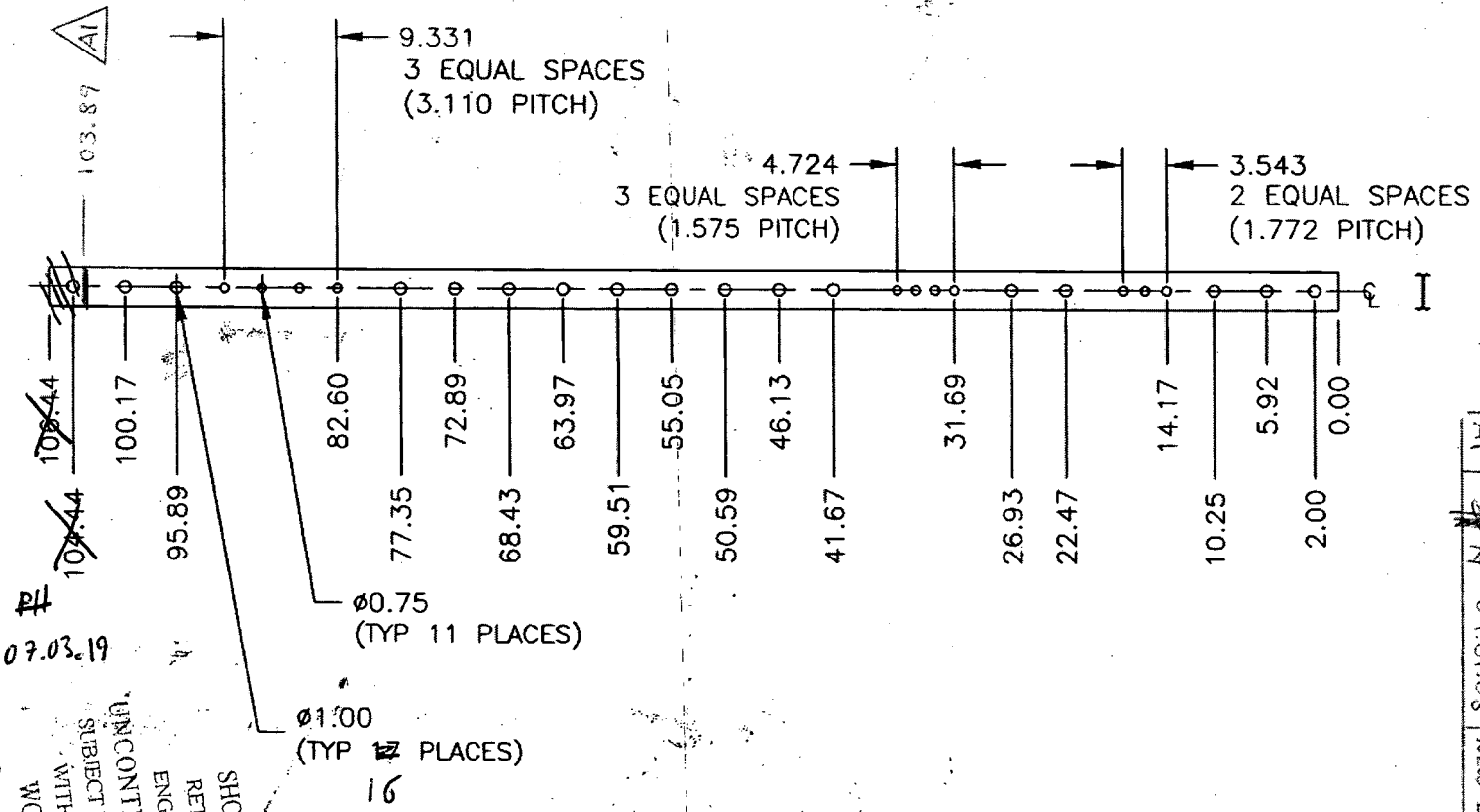
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO COPY ISSUED

DESIGN	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED MTH	DRAWING NO. D2905	REV. A SHEET 1 OF 1
DATE 99.09.14	TITLE WEB SCALE 1:15		
A	99.09.14	NEW ISSUE	
A1	04.01.08	NEW LENGTH 103.89 WAS 106.414	

44-09.28 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:
MAKE FROM D2600-5 EXTRUSION
ALL HOLES ON CENTERLINE
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

